

Date: Tuesday, 10/03/2009 11:27:50 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BAR
Job Number	: 46398		
Estimate Number	: 13480		
P.O. Number	:	Part Number	: D38061
This Issue	: 10/03/2009 S.O. No. :	Drawing Number	: D3806 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 45480	Material	:
Written By	:	Due Date	: 17/03/2009 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A 08-07-21 new issue DD verified by:ec : Est Rev:B 08-09-23 redesign DD verified by:EC : Est Rev:C 08-09-30 redesign DD verified by:EC : Est Rev:D 09-03-04 rev.a as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0500X2500	304 BAR .500 x 2.50
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Comment: Qty.: 0.8820 f(s)/Unit Total : 1.7640 f(s)

304 BAR .500 x 2.50

batch: 110966

ml 09 03 10

(2)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3806

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

ml 09 03 10

(2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ml 09 03 10

(2)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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090310 (2)

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-drill holes as per dwg D3806

2-deburr

FF 09-03-11

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

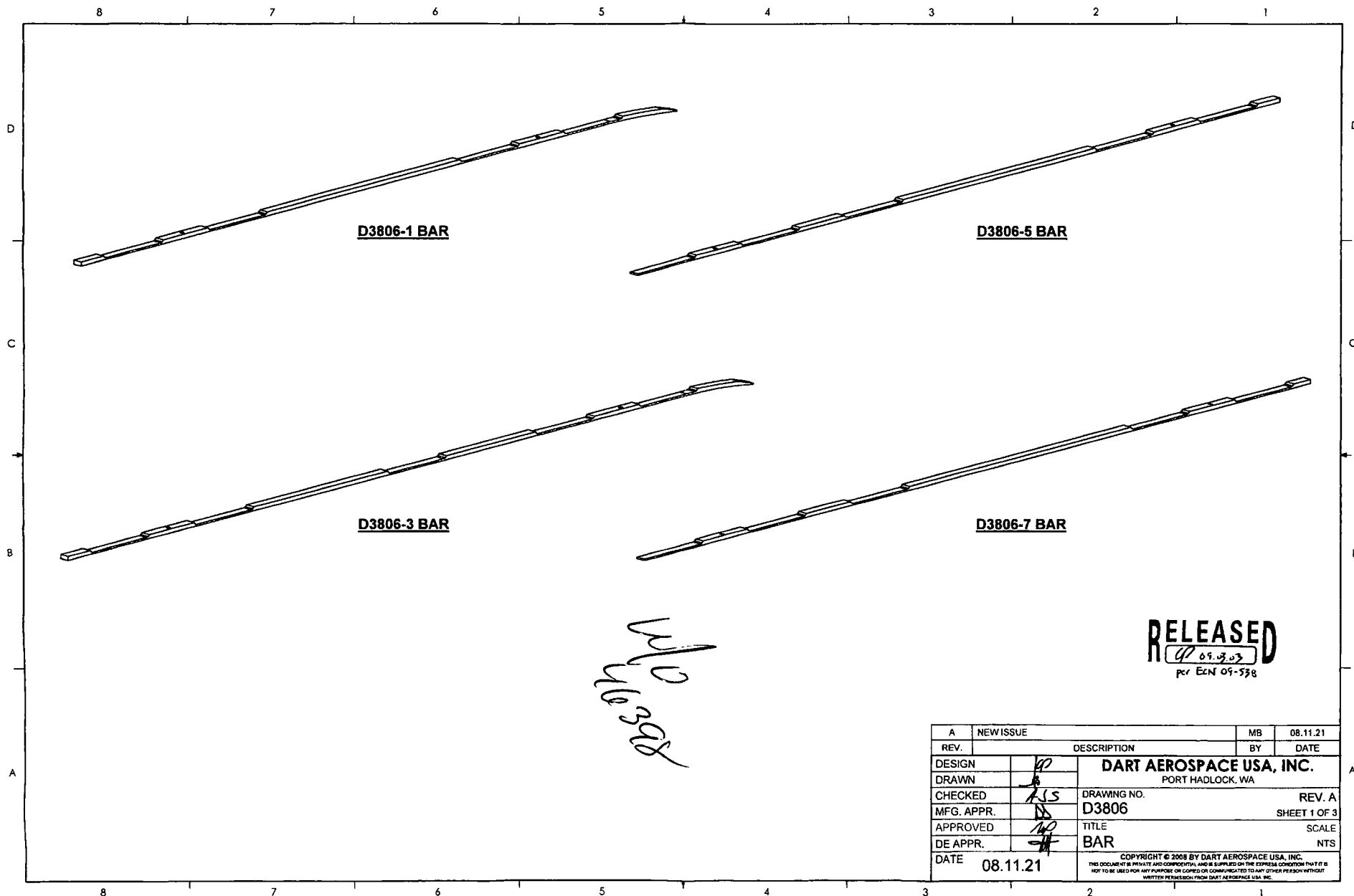
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

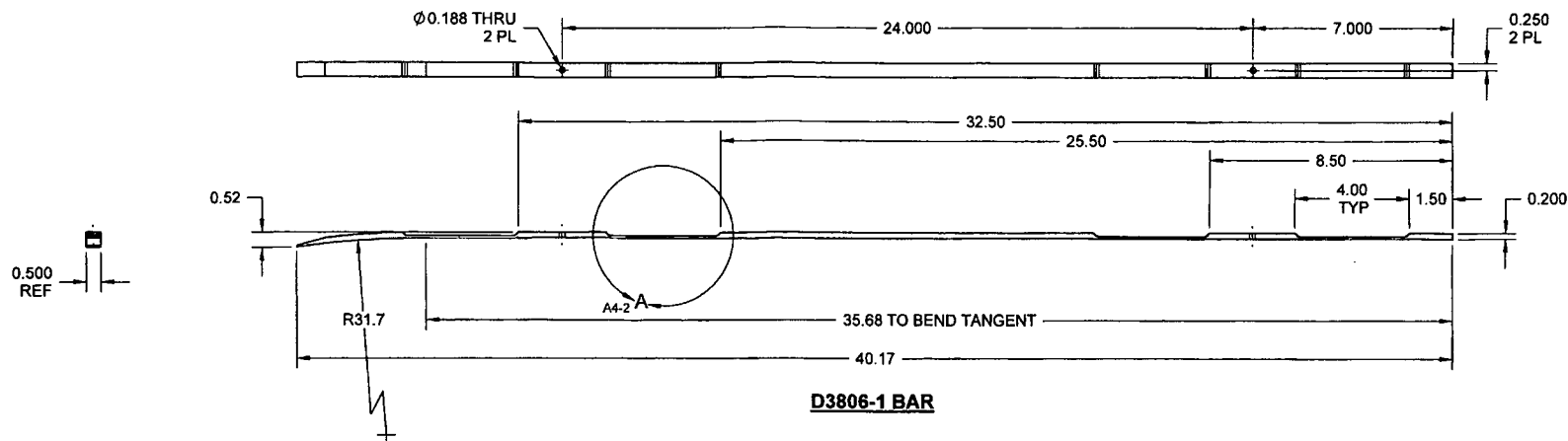
C

B

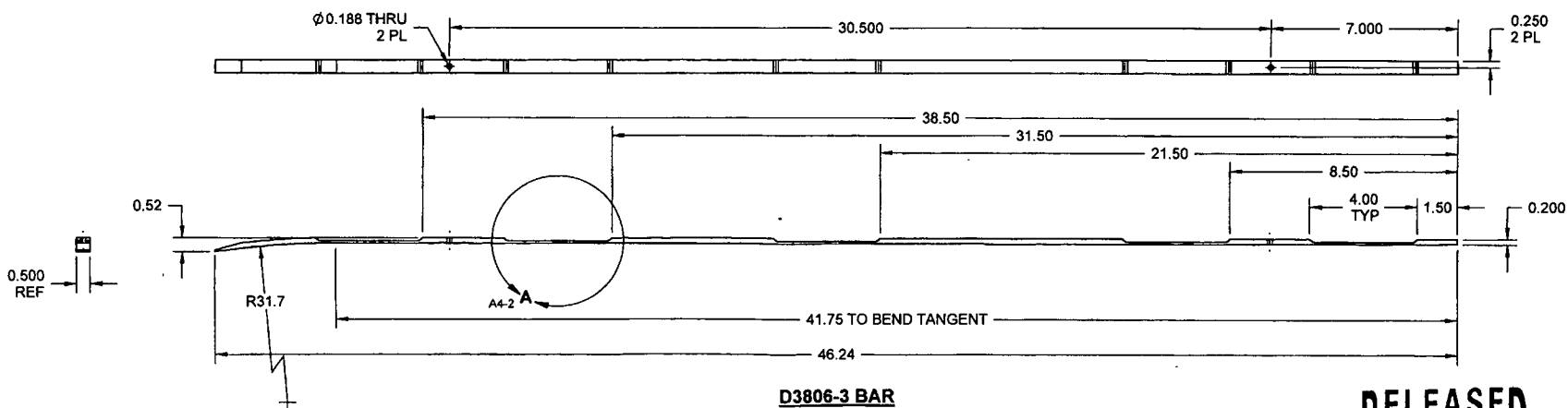
B

A

A



D3806-1 BAR



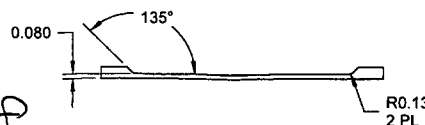
D3806-3 BAR

RELEASED
09.13.03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.500 THICK
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-1 = 0.87 lbs
D3806-3 = 0.98 lbs

46398



DETAIL A
TYP, SCALE 2X

DESIGN	47	DART AEROSPACE USA, INC.	
DRAWN	JS	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3806	SHEET 2 OF 3
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BAR	NTS
DATE	08.11.21	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1

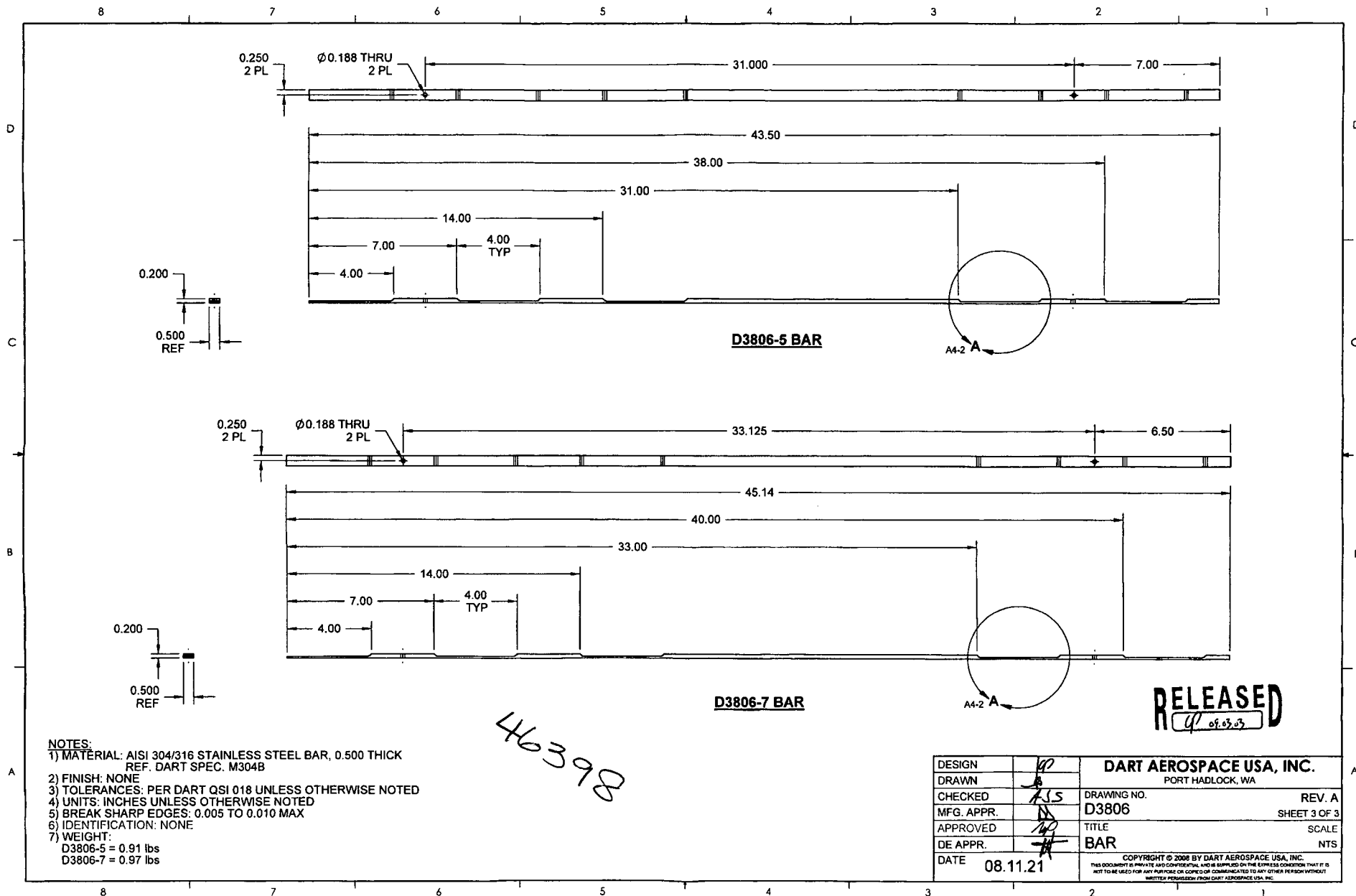
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